

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-015612**Date Inspected:** 13-Jul-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Liu Yang, Yu Dong Ping**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Welder Qualification**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Dan Hernandez was present during the times noted above to observe the fit up, welding and related activities associated with the fabrication of the San Francisco Oakland Bay Self Anchored Suspension Bridge at Zhenhua Port Machinery Company (ZPMC) facility on Changxing Island.

Bay 11

This QA Inspector observed Welder Qualification using the Shielded Metal Arc Welding (SMAW) process with an E7018 electrode for Complete Joint Penetration (CJP) Groove Tests for plate of unlimited thickness (25mm test plate) in the 3G (vertical) position and 4G (overhead) positions and Fillet Weld Tack Welder Qualification Test in the 3F (vertical) position and 4F (overhead) position.

Personnel, position and WPS are as follows:

4G CJP

WPS-B-P-2214-B-U2a

Hu Jilian

Chen Shangchun

Wang Xiaomin

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Xie Zhongchen
Xu Naisheng
Han Kui
Cui Guozhong
Xu Naijun
Zhu Tongxin
Li Mengqian
Zhao Guitin
Xu Hua
Li Xinping
Li Jinquan
Chen Rui
Zhang Qiujun
Xue Yian
Liang Shihai
Cao Hu

3G CJP

WPS-B-P-2213-B-U2a

Zhao Guitin
Xu Hua
Chen Rui
Zhang Qiujun
Zhang Fengmei
Wang Cheng
Xue Yian
Liang Shihai
Cao Hu

3F Tack welder

WPS-B-P-2113

Sun Kang
Ma Guijun
Gong Ruiqiang
Xue Futai
Mao Zhengzhong
Gao Fuchao
Lu Gangwei
Lu Yongquan
Hou Wuren

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Guo Hui
Wu Wenkai
Wang Wenbin
Zhang Yanjun
Zhang Anlong
Wang Yanwu
Guo Zhonghua
Guo Xingchen
Zhang Shaoliang

4F Tack welder

WPS-B-P-2114

Sun Kang
Ma Guijun
Gong Ruiqiang
Mao Zhengzhong
Gao Fuchao
Lu Gangwei
Lu Yongquan
Hou Wuren
Guo Hui
Wu Wenkai
Wang Wenbin
Zhang Yanjun
Zhang Anlong
Wang Yanwu
Guo Zhonghua
Guo Xingchen
Zhang Shaoliang

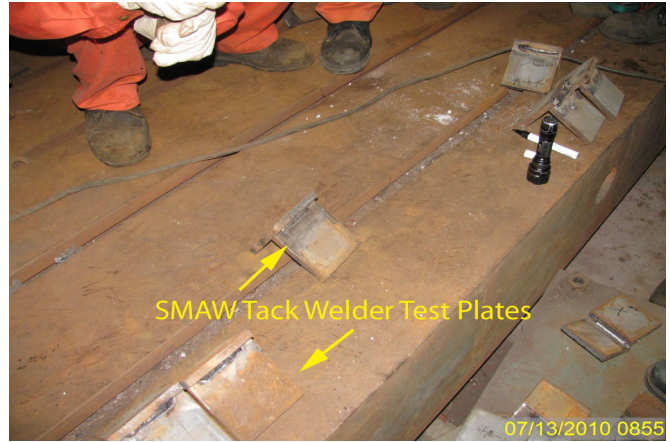
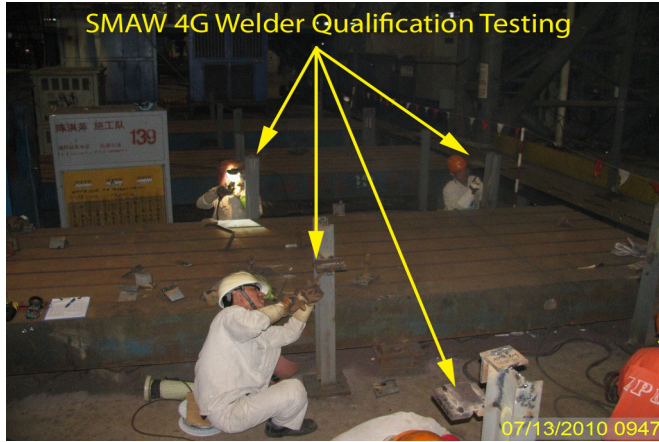
ZPMC QC CWI Liu Yang and CWI Yu Dong Ping were present during Welder qualification. 3G and 4G test coupons will be sent to ZPMC weld lab for Radiographic Testing and Mechanical Bend Tests.

Visual for CJP test plates and Tack weld Visual and Fracture Testing results were accepted by ZPMC QC.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

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Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, 150-0042-2372 , who represents the Office of Structural Materials for your project.

Inspected By: Hernandez,Dan

Quality Assurance Inspector

Reviewed By: Peterson,Art

QA Reviewer